



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

649.4816
Job Sheet 168763



Part No: 649.4816

Job Qty: 20 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/22/17

Job Tracking No:

Due Date: 11/27/17

Created By: Mario Poulin

Type: AOG

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		11/25/17	0.00	0.00	Start Up Container		SC
110	Waterjet	20 pcs		11/27/17	0.00	2.86	Waterjet1		SC
120	QC	20 pcs		11/27/17	0.00	0.00	QC2		SC DAS 38 9-89
130	QC	20 pcs		11/27/17	0.00	0.00	QC8		
160	Outsource	20 pcs		11/27/17			ATG001-VC		
170	Packaging	20 pcs		11/27/17	0.00	0.00	Packaging2		
180	QC	20 pcs		11/27/17	0.00	0.00	QC5		
210	Packaging	20 pcs		11/27/17	0.00	0.00	Packaging3		
220	QC21-SA	20 Ea		11/27/17	0.00	0.00	QC21		DAS 21 DEC 01 2017
230	Rework	20 pcs		11/27/17	0.00	0.00	Small Fab		9-09

Part Op 110 - 1-Cut as per Dwg Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: 160 - ISSUE P/O: 6038474 AS PER DWG 649.4800 PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Primer 1.3 mils red

NOV 24 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.125	15	17	0	0

Part Specifications

Specifications could not be found.

Plex 11/22/17 1:33 PM dart.poulin.mario

DQA: _____ Date: _____

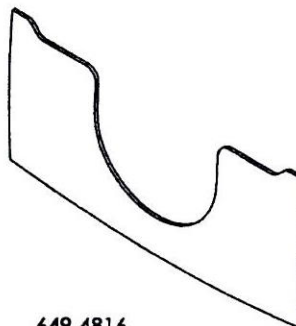
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

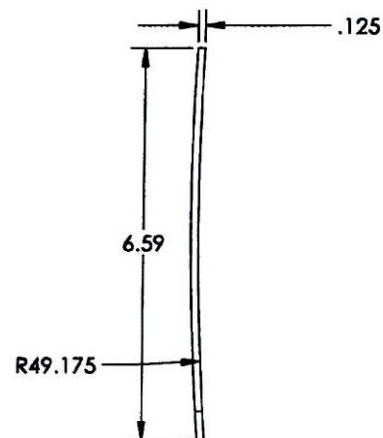
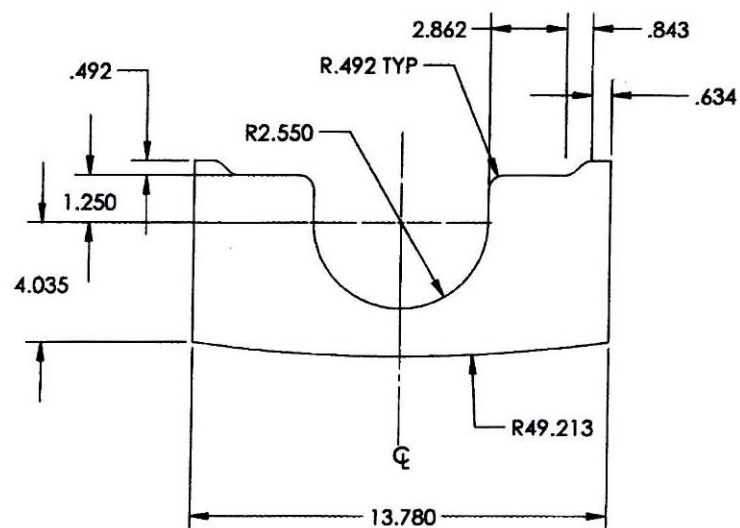
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
DART AEROSPACE S012648 Doubler Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com				Position Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval					
PART NO: Revision: Operation: Change No:		649.4816 Start up Operation Mfg Date: 11/22/17 Job No: 168763		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐					
		Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____							

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649.4816



ORIGINAL DATE 11-02-11		3030 ENTERPRISE CT., SUITE A	
DRAWN BY A. GUAN		VISTA, CA 92081	
CHECKED BY P. BRAYO		(760) 724-5300	
DRAWING APPROVAL 11-02-11		APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.001 ANGLES ±.5°		SHEET B	REV. D
CAGE CODE 07M26		DWG. NO. 649.4800	
SCALE NONE		SHEET 5 OF 8	



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER PO038474

Items												
Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
				Conformity is required								
5	168733	RBEM632V3009123-1	-	Frame Weldment -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL- A-8625F TYPE 2 CLASS 1 WATER SEAL AS PER DWG RBEM632V3009123-1 REV.C		Firmed	12/1/17	1 pcs	0 pcs	1 pcs	\$18.95/pcs	\$18.95
6	168763	649.4816	-	Doubler ISSUE P/O: AS PER DWG 649.4800 PRIME IAW MIL-P- 23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)		Firmed	12/1/17	12 pcs	0 pcs	12 pcs	\$36.45/pcs	\$437.40
											Grand Total: \$1,436.75	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/28/17 3:36 PM Dart.baker.diane



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914209

Date: 30-Nov-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
12 ea	Part: 649.4816 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22055	Rev: B	PO: PO038474
	Line: 6		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>30/11/2017</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: 649.4816 Revision: Doubler														
130	QC	S012648	168763	12 pcs	0	S012648	ATG001-VC		WIP	11/22/2017	Issue Container			
Operation Totals:		1		12	0									
Part Totals:		1		12	0									
Part Number: M2024T3S.125 Revision: 2024-T3 .125 Sheet														
100	Receive sf	S012642	168763	0 sf	0	M137653	MAT021		Stock	11/22/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		12	0									

Plex 1/8/2018 11:52 AM Dart.Boucher.Sylvie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					